

Work Order ID 161553***161553***

Page 1

Wednesday, May 17, 2017 3:25:37 PM

Item ID: D5352-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cushion
Start Date: 5/18/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 5/19/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference: SCHEDULED/U
Approvals: Process Plan:  Date: MAY 17 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5352	C

105

0.00

105

HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER FOLIO FA889

FOLIO REV: AADWG REV: C20Ø

DAS

20

9-89

17-05-18

115

QC2- Inspect parts off machine FAI/FAIB

0.00

115

QC

Quality Control

Memo

20Ø

DAS

20

9-89

17-05-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

Work Order ID 161553

Wednesday, May 17, 2017 3:25:37 PM

161553

Page 2

Item ID: D5352-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cushion
 Start Date: 5/18/2017 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 5/19/2017 Req'd Qty: 20.00 ***20*** Customer:
 Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 *125* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				20	0		DAS 14 9-89 17/05/18
135 *135* Packaging Packaging	Identify as per dwg & Stock Location: 51515 Memo	0.00 0.00				20			DAS 6 9-89 MAY 18 2017
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 2.00							17/5/23 DAS 21 9-89 MAY 18 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

Page 1

Wednesday, May 17, 2017 3:25:42 PM

Work Order ID: 161553

161553

Parent Item: D5352-1

D5352-1

Parent Item Name: Cushion

Start Date: 5/18/2017

Required Date: 5/19/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 15.11.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4287-1		Manufactured	No				f	21.5400		52			
D4287-1									**	4.394'		DAS 20 9-89	17-05-18
Uhmw U-Channel													

Location

Loc Qty

Loc Code

ST478a

21.54

152413

21.54

4.394'

DQA: _____ Date: _____

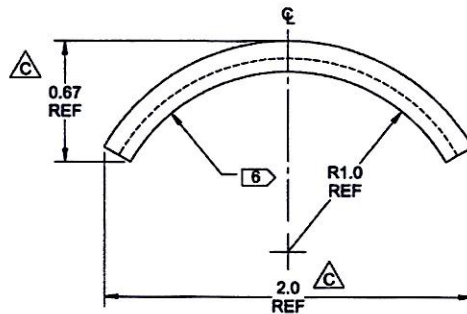
WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

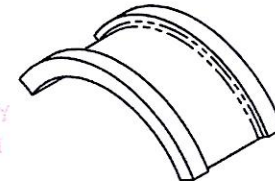
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

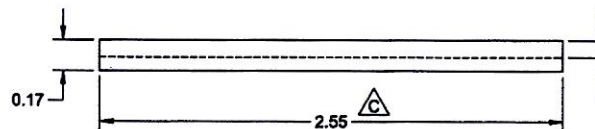


D5352-1 CUSHION
(MAKE FROM D5352-1F)
(COLD FORMED DURING INSTALLATION, DIMS REFERENCE ONLY)

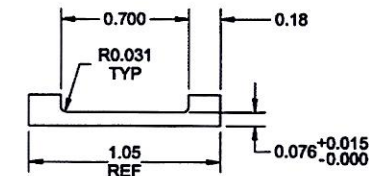
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **161553**



MAY 17 2017



D5352-1F FLAT MACHINED STATE 1



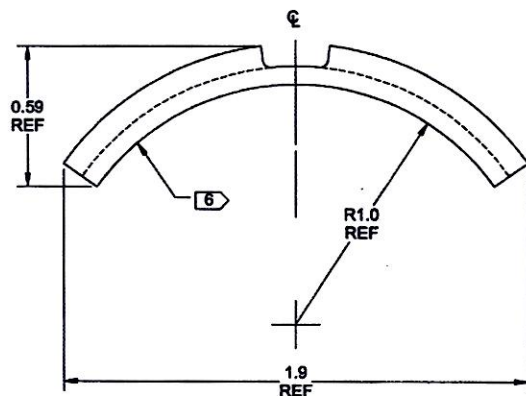
NOTES:

- 1) MATERIAL: MAKE FROM D4287-1 OR VIRGIN GAR-DUR UHMW-PE, NATURAL, (GARLAND MANUFACTURING COMPANY)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

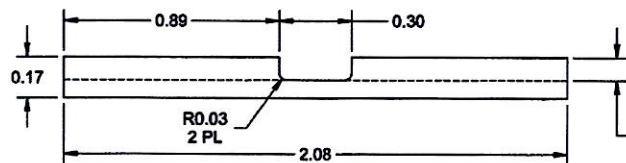
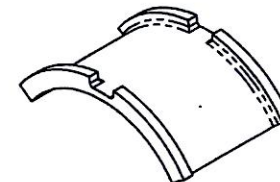
RELEASED
2017-03-22
2017-535

APPROVED

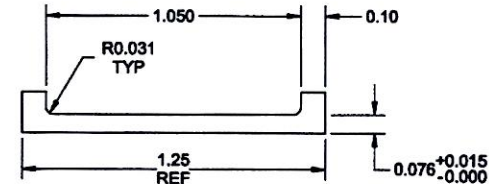
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B	ADD PURCHASING OPTION- NEW SUPPLIER REASON: CIR10-09	DB	16.05.09
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	DD	D5352	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 CUSHION	NTS
DATE	17.02.09	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D5352-3 CUSHION
(MAKE FROM D5352-3F)
(COLD FORMED DURING INSTALLATION, DIMS REFERENCE ONLY)



D5352-3F FLAT MACHINED STATE 1



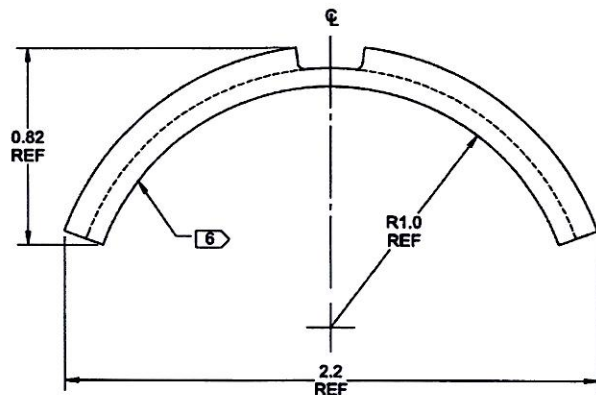
NOTES:

- 1) MATERIAL: MAKE FROM D4287-3 OR VIRGIN GAR-DUR UHMW-PE, NATURAL (GARLAND MFG COMPANY)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

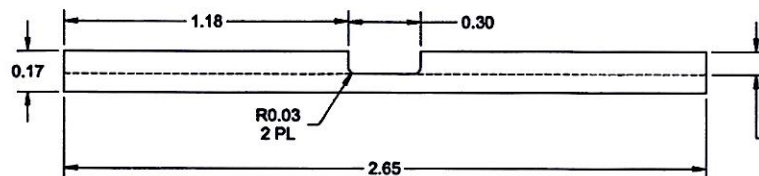
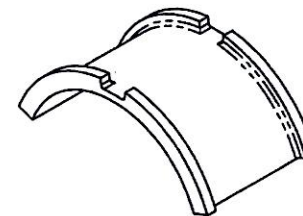
RELEASED
2017-03-22

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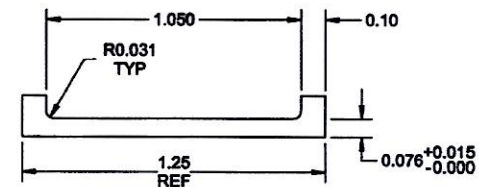
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DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	DD	D5352	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 CUSHION	NTS
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D5352-5 CUSHION
(MAKE FROM D5352-5F)
(COLD FORMED DURING INSTALLATION, DIMS REFERENCE ONLY)



D5352-5F FLAT MACHINED STATE 1



NOTES:

- 1) MATERIAL: MAKE FROM D4287-3 OR VIRGIN GAR-DUR UHMW-PE, NATURAL (GARLAND MFG COMPANY)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

RELEASE
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	VS	D5352	SHEET 3 OF 3
MFG. APPR.	DD	TITLE	SCALE
APPROVED	HS	R66 CUSHION	NTS
DE APPR.	DS	COPYRIGHT © 2015 BY DART AEROSPACE LTD	
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